

Work Order ID 59664

Wednesday, June 09, 2010 11:40:26 AM

Page 1

Item ID: D3780-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Armrest Assembly

Start Date: 6/9/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 6/6/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3780

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Identify as per dwg & Stock Location:

261

Packaging

Memo

0.00

Packaging



8/5/09/27 (3)

(x3)

8/10/08 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/28 AJ

BA 10-9-28

(3)

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Picklist Print

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Work Order ID: 59664

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 6/9/2010

Required Date: 7/2/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3696-041		Manufactured	No			100	Each	8.0000	1	4			
Arm Assembly													

Location Loc Qty Loc Code

ST205 2
44542 2
ST255 6
56900 2
58010 4

D3781-041

Manufactured No

100 Each

1.0000

1

4



Lateral Cushion Assembly

Location Loc Qty Loc Code

ST185 1
47992 1

D3781-043

Manufactured No

100 Each

4.0000

1

4



Armrest Cushion Assembly

Location Loc Qty Loc Code

ST185 4
48436 1
56902 3

D3785-3

Manufactured No

100 Each

6.0000

1

4



Bracket

Location Loc Qty Loc Code

ST088 6
56903 6

SB 10/09/24
SB 10/09/27
BG1788 (3x)
SB 10/09/24
SB 10/09/24
3

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Parent Item Name: Armrest Assembly









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Start Date: 6/9/2010

Required Date: 7/2/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3977-1		Manufactured	No			100	Each	9.0000	1	4			
												SB	10/09/24
Bolt													
				<u>Location</u>					<u>Loc Qty</u>	<u>Loc Code</u>			
				ST105					9				
				55180					9			3	
D3978-1		Manufactured	No			100	Each	9.0000	1	4			
												SB	10/09/24
Nut													
				<u>Location</u>					<u>Loc Qty</u>	<u>Loc Code</u>			
				ST105					9				
				55182					9			3	
D3979-1		Manufactured	No			100	Each	30.0000	1	4			
												SB	10/09/24
Washer													
				<u>Location</u>					<u>Loc Qty</u>	<u>Loc Code</u>			
				ST105					30				
				55183					30			3	
AN960JD10L	NAS1149D0332J	Purchased	No			100	Each	3,795.000	2	8			
												SB	10/09/24
Washer													
				<u>Location</u>					<u>Loc Qty</u>	<u>Loc Code</u>			
				ST348					3795				
				110985					3795				
				M 114348									

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN970-6		Purchased	No			100	Each	41.0000	2	8			
Washer													



SB 10/09/24

Location

Loc Qty

Loc Code

ST349

41

2

114341

41

4

MS21042L3

Purchased

No

100

Each

3,346.000

2

8



SB 10/09/24

Nut

Location

Loc Qty

Loc Code

ST300

3346

113537

18

113644

3

114523

825

114718

500

114784

2000

6

MS24665-302

Purchased

No

100

Each

62.0000

1

4



SB 10/09/24

Cotter Pin

Location

Loc Qty

Loc Code

ST309

62

113644

62

3

Wednesday, June 09, 2010 11:40:30 AM

Shop Packet Print

Page 3

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Start Date: 6/9/2010

Required Date: 7/2/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS24693-C272		Purchased	No			100	Each	1,296.000	2	8			



Screw



50 10/09/24

Location	Loc Qty	Loc Code
ST310	1296	
17137	477	
17831	519	
9370	300	

6

MS24693-C277 Purchased

No

100 Each

42.0000

2

8



Screw



50 10/09/24

Location	Loc Qty	Loc Code
ST310	42	
109297	4	
113644	38	

6

NAS1149D06631 Purchased

No

100 Each

156.0000

1

4



Washer



50 10/09/24

Location	Loc Qty	Loc Code
ST298	156	
113524	4	
114348	152	

3

M 115698

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NOTE: Date & initial all entries

8

7

6

5

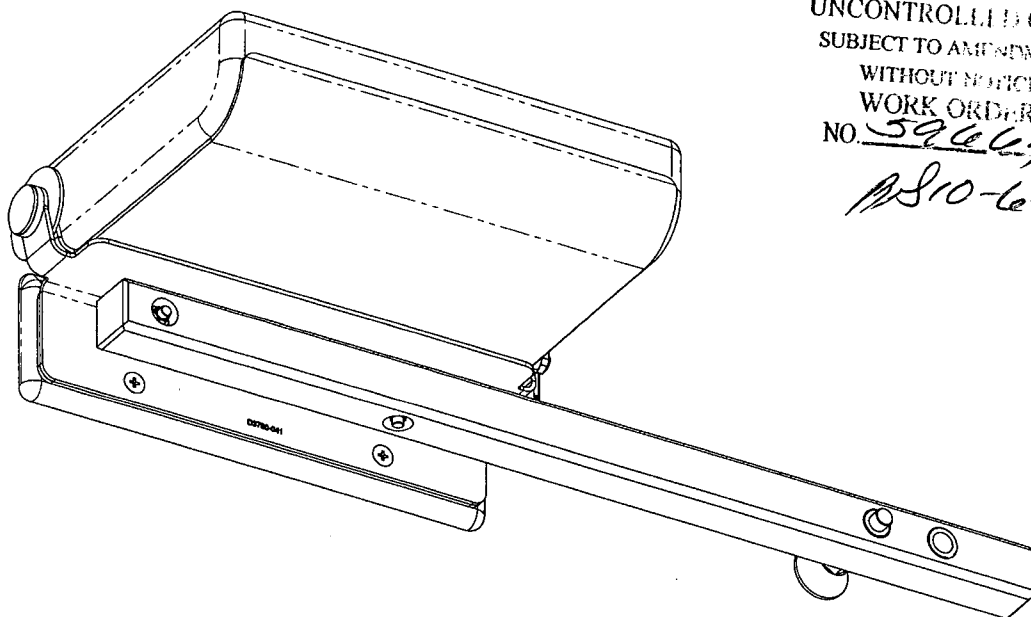
4

3

2

1

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59664
MS10-6-09



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

RELEASED
09/07/21/144

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3780 REV. D TITLE ARMREST ASSEMBLY SCALE NTS SHEET 1 OF 3 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

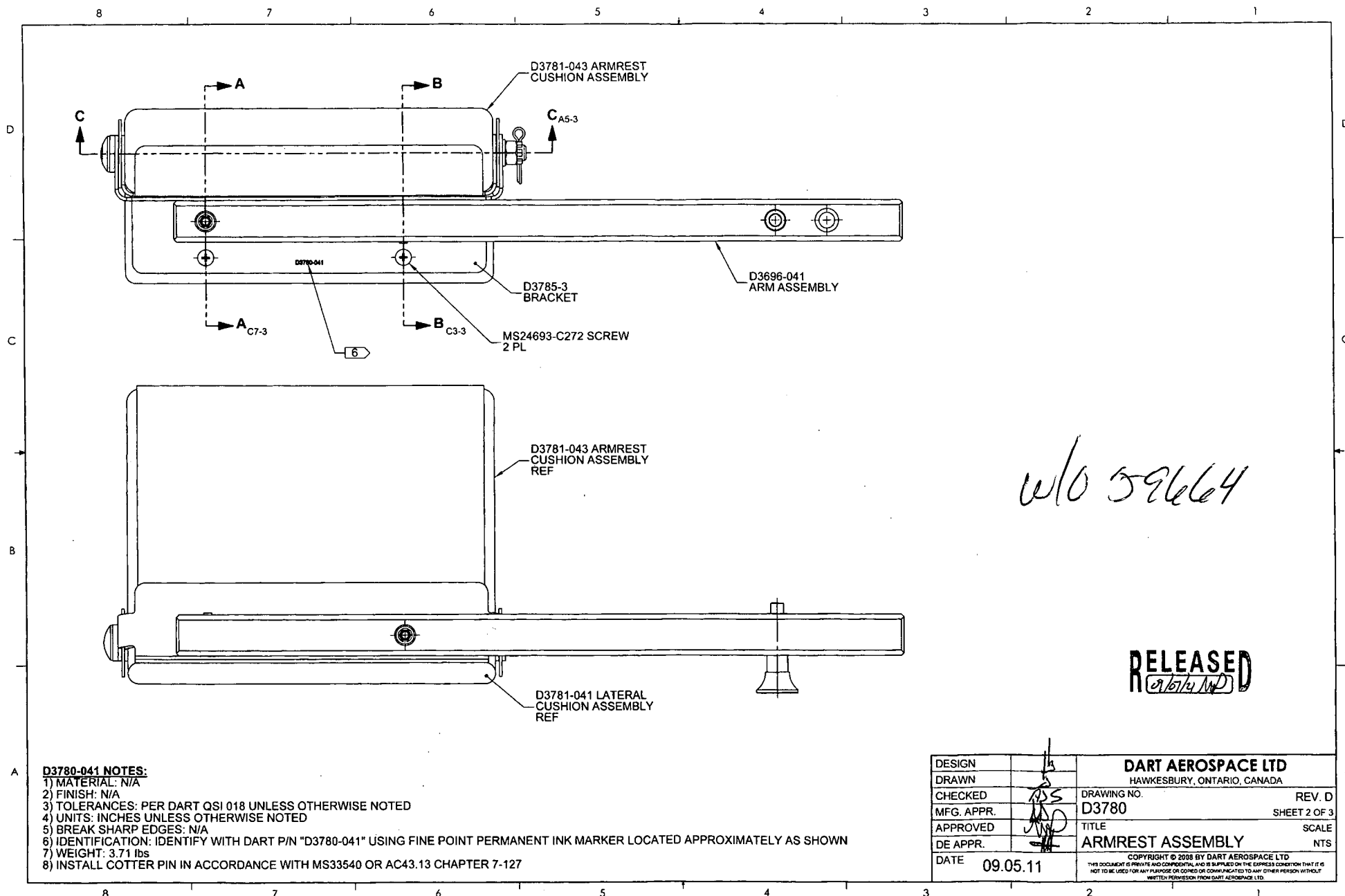
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D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

MS21042L3
NUT
AN960JD10L
WASHER
MS24693-C272
SCREW
MS24693-C277
SCREW

SECTION A-A C7-2

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3785-3
BRACKET
REF
AN960JD10L
WASHER
MS21042L3
NUT
MS24693-C272
SCREW

SECTION B-B C6-2

W/O 59664

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN 8

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3979-1 WASHER (SQUARE HOLE)

SECTION C-C D5-2
SCALE: 2X

RELEASED
07/04/11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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